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D120-639-011
Job Sheet 184443



Part No: D120-639-011

Job Qty: 2 ea

Part Name: OEM Replacement Wearplate (s/n 1001 thru 1390)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 10/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI 9223 REV A, IIN-D120-639 REV A IPP D 02.09.13 Re-format, Added MS27130-S30 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	2 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Stores/Pkg-1	
105	Packaging	2 pcs	10/10/18	10/10/18	0.00	0.00	Packaging1-1	
110	QC	2 pcs	10/10/18	10/10/18	0.00	0.00	QC4	
115	DC	2 pcs	10/10/18	10/10/18	0.00	0.00	DC	
120	Packaging	2 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3-1	
130	QC21-FG	2 Ea	10/10/18	10/10/18	0.00	0.00	QC21	

Part Op 115 - Photocopy bluefile and type labels per PPP D120-639-011 CHG 002
Descriptions: 120 - Package and Identify as per PPP D120-639-011

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
ALS7-1032-130	Rivnut	72 Ea (36 ea)	90-Start up Operation	5006239X50 5007389X22
D2648-3	Wearpad	10 Ea (5 ea)	90-Start up Operation	5112551X5 5068700X5
D2656-13	Wearplate Fwd	2 Ea (1 ea)	90-Start up Operation	5069800
D2656-31	Wearplate	2 Ea (1 ea)	90-Start up Operation	5069651X1 512600X1
D2746	Wearplate	2 Ea (1 ea)	90-Start up Operation	5113187
MS27039-1-08	Screw	80 Ea (40 ea)	90-Start up Operation	5104017
MS27130-S30	Insert	8 Ea (4 ea)	90-Start up Operation	F100154
NAS1149D0332J	Washer	80 Ea (40 ea)	90-Start up Operation	5100407

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	ALS7-1032-130	72	2,117	0
	D2648-3	10	12	0
	D2656-13	2	2	0
	D2656-31	2	3	0
	D2746	2	3	0
	MS27039-1-08	80	471	0
	MS27130-S30	8	53	0
	NAS1149D0332J	80	2,311	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:33%;">Water Jet ☐</td> <td style="width:33%;">Engineering ☐</td> </tr> <tr> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Supplier ☐</td> <td></td> </tr> </table>				Water Jet ☐	Engineering ☐	Prod. Eng. Coord. ☐	Quality ☐	Rec/Store/Packaging ☐	Other ☐	Supplier ☐	
Water Jet ☐	Engineering ☐														
Prod. Eng. Coord. ☐	Quality ☐														
Rec/Store/Packaging ☐	Other ☐														
Supplier ☐															
Date : _____		Step #: _____		MRB (QSI042) Approval											

Specifications could not be found.

Plex 10/10/18 7:23 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

REFERENCE ONLY

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
1	1	D2746	WEARPLATE
1	1	D2656-31	WEARPLATE
1	1	D2656-13	WEARPLATE
5		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
40	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
40	40	MS27039-1-08	SCREW
40	40	AN960JD10L	WASHER

REFERENCE ONLY

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Revision: **A**
Date: 00.12.11

DART

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

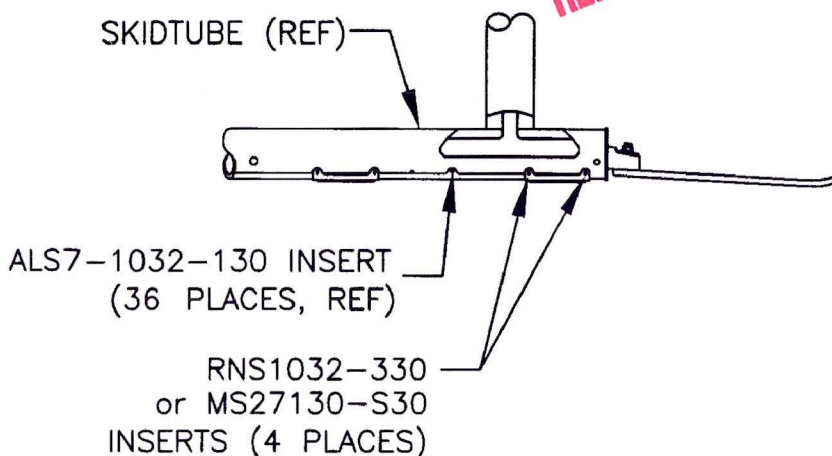
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

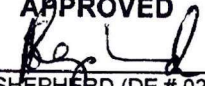
QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT

REFERENCE ONLY

NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD
OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	 D. SHEPHERD (DE # 02)
DATE:	NOV 19, 2001
CERT. NO.:	SH01-25
ISSUE NO.:	1

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